

304 1 1/2"

Work Order ID 146837

Monday, May 30, 2016 8:11:50 AM

146837

Page 1

Item ID: D3443-3

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Clevis

Start Date: 5/17/2016 Start Qty: 12.00

12

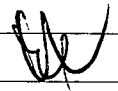
Cust Item ID:

Required Date: 5/24/2016 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan:  Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3443	Rev C

100 0.00

100

Doosan

Memo

1.84

Doosan Lathe

1-TURN AS PER FOLIO FA588 & DWG D3443

FOLIO REV: AA

DWG REV: e

2-DEBURR AS REQUIRED

13 ϕ DAS 45 9-89 2016-6-13

150 QC2- Inspect parts off machine FAI/FAIB 0.00

150

QC

Memo

0.02

Quality Control

13 ϕ DAS 45 9-89 2016-6-13 910 →

160 QC8- Inspect parts - second check 0.00

160

QC

Memo

0.04

Quality Control

15 ϕ DAS 49 9-89 16/06/15

DQA:

Date: 16.06.21



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date: 16.06.17

Work Order update only ☐

Work Order: <u>146837</u> Part No. <u>D3443-3</u> NCR No. <u>16-5847</u>		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☒ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☒</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☒	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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Date: <u>14/14</u>		Step #: <u>100</u>		QTY Effective: <u>2</u>		MRB (QSI042) Approval DAS 12 9-89 <u>16/6/14</u>																																																																	
Description Work Order Deviation $\phi 0.500^{+0}_{-0.005}$ dim is 0.475				Disposition Acceptable. Assembled into D3443-043 strut which was doesn't show any bonding. Does not effect strength of welded joint.				Completed By DAS 45 <u>2016-614</u> 9-89 Lead hand / Supervisor Approval Verification <u>B. 16/06/14</u>																																																															
				QC / QA Coordinator Approval <u>D 160615</u>																																																																			
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Work Order ID 146837

Monday, May 30, 2016 8:11:50 AM

146837

Page 2

Item ID: D3443-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Clevis

Start Date: 5/17/2016 Start Qty: 12.00

12

Cust Item ID:

Required Date: 5/24/2016 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: _____	0.00							
170									
Packaging	Memo	0.02							
Packaging	*****STOCK IN LARGE FAB***** LOCATION: WA002								
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.20							
Quality Control									

JUN 16 2016

DMS
6
8:26

ML5 JUN 16 2016

JUN 16 2016

ML5

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

Monday, May 30, 2016 8:11:49 AM

Page 1

Work Order ID: 146837

146837

Parent Item: D3443-3

D3443-3

Parent Item Name: Clevis

Start Date: 5/17/2016

Required Date: 5/24/2016

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev: A05.11.14New issueEC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304R1.500		Purchased			No	100	f	16.3500	0.25	3			

M304R1 500

304 round bar 1.500

Location

MAT029

m127818

m131392

Loc Qty

16.35

2.6

13.75

Loc Code

1.19
2.17

DAS

45

9-89

2016-6-13

1336

DQA: _____ Date: _____



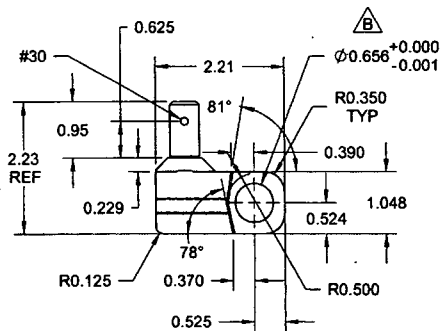
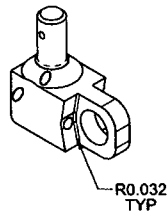
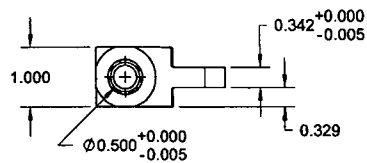
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

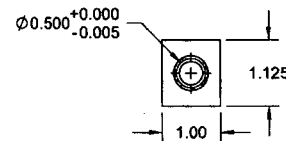
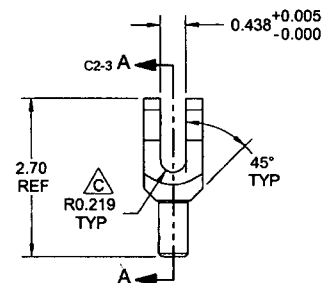
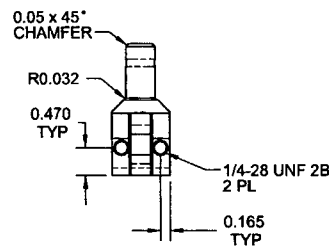
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;"></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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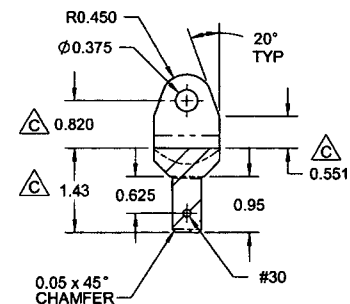
8 7 6 5 4 3 2 1



D3443-1 LUG



D3443-3 CLEVIS



SECTION A-A C4-3



NOTES:

- 1) MATERIAL: D3443-1 = 17-4 SS PER AMS 5604/5643 (REF DART SPEC M17-4B)
D3443-3 = AISI 304 SS ROUND BAR (REF. DART SPEC M304R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3443-1 = 0.50 lbs
D3443-3 = 0.35 lbs

W/O 146837

RELEASED
09/08/25/14

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	UP	DRAWING NO.	REV. C
MFG. APPR.		D3443	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		STRUT WELDMENT ASSEMBLY NTS	
DATE	09.06.25	COPYRIGHT © 2005 BY DART AEROSPACE LTD	
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